

Threadinsert 1-side LxH 15.88 x 15.75

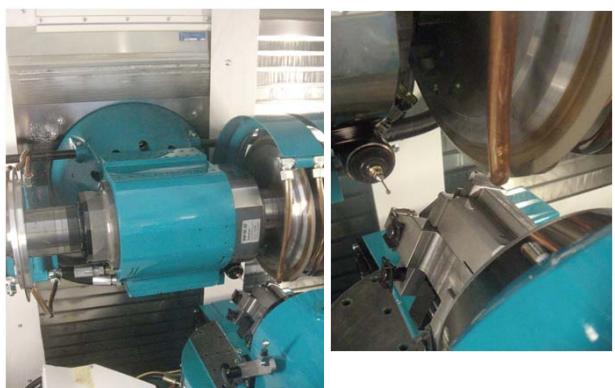
A08-010

The onesided Threadinsert with single threadform can be ground in one setup in standard RPC or CTC clamping. The plunge roughing operation uses a 1A1 of 2 mm thickness. The pregrinding and finishing operations are using rigid 40 degree V-shaped wheels of diameter 300 mm.



1. Cycletime for Production

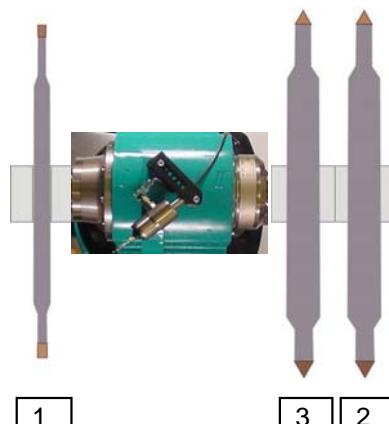
Workpiece:	L 15.88 x 15.75 x 4.76		
Material CARBIDE			
Operations	PlungRough	Pregrinding	Finishing
Feed [mm/Min]	25	25	25
Power [kW]	2	1	2
Cutting feed [m/s]	24	24	24
Used wheels	1	2	3
Grinding time [s]	166	71	71
Total cycle time	5 Min 23		



The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	14A1 Ø250 D64
2	14V1 Ø300 D76V40°
3	14V1 Ø300 D64V40°



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : SIRIUS HPM

Coolant: Synthetic Oil, pressure 6 bar

Control: Fanuc 31i

Software: Quinto 5

Accessories: STL6051

Responsible engineer: OP. 4.6.10

www.schneeberger.ch

J. SCHNEEBERGER Maschinen AG 4914 Roggwil Switzerland

Subsidiaries in: France, Deutschland, Italia, United States, China